

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010787**Date Inspected:** 21-Dec-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 6AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA025-002. The welder is identified as #048659 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as SEG027-044. The welder is identified as #048659 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

This QA Inspector observed match drilling of bolt holes in Bottom Plate WT stiffener webs for splice plate connection.

WELDING INSPECTION REPORT

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Segment 6AW/6BW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as OBW6B-002. The welder is identified as #067571 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-T-2214-B-U2-FCM-1.

This QA Inspector observed arc gouging of remaining portions of fit up plates from Deck Plate, interior.

Segment 5CW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a Complete Joint Penetration (CJP) weld joint. The Weld joint is designated as CA022-002. The welder is identified as #048659 and was observed welding in the 4G (overhead) position using approved Welding Procedure Specification WPS-B-P-2214-TC-U4b-FCM-1.

Segment 5BW/5CW

This QA Inspector observed ABF personnel performing Ultrasonic Testing (UT) of Edge Plate CJP segment splice, counter weight side.

ZPMC Quality Control (QC) Inspector is identified as Fang Ya Jun. QA Inspector observed QC Inspector verify welding parameters. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

Inspected By:	Hernandez,Dan	Quality Assurance Inspector
Reviewed By:	Miller,Mark	QA Reviewer
